

Date: Tuesday, 20/11/2007 2:37:26 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CHAFING SHIELD
Job Number : 35903
Estimate Number : 10840
P.O. Number : *N/A*
This Issue : 20/11/2007 S.O. No. : *N/A*
Prsht Rev. : NC
First Issue : *N/A* Type : SMALL /MED FAB
Previous Run : 33561
Part Number : D31891
Drawing Number : D3189 REV B
Project Number : N/A
Drawing Revision : B
Material : *N/A*
Due Date : 20/11/2007 Qty: *4* Um: Each
Written By :
Checked & Approved By :
Comment : Est. B 05.08.22 No longer made in-house KJ/JLM
Est Rev:C 06-03-24 Rolling Now made in House JLM
Est Rev:D 07-04-16 As per Rev B JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S26GA 304/316 0.018 SHEET



Comment: Qty.: 0.3360 sf(s)/Unit Total: 2.0160 sf(s) ?
304/316 SS .020" Sheet
(M304S25GA)
Batch: *M 105592*

FF 07-11-20

4

2.0 SHEAR SHEAR



Comment: SHEAR
Cut to size as per Dwg D3189

FF 07-11-20

4

3.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr & Grind Rads as per Dwg D3189

2-Roll as per Dwg D3189

FF 07-11-20

4

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 07/11/21 (x4)

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/11/21 (4)

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Process Sheet

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Drawing Name: CHAFING SHIELD

Job Number: 35903

Part Number: D31891

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

④
20/11/22

Job Completion



U 20.11.22

DART

DESIGN	92	DRAWN BY	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3189	REV. B SHEET 1 OF 2
DATE	07.01.05			TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.08			NEW ISSUE	
B	07.01.05			ADD -3	

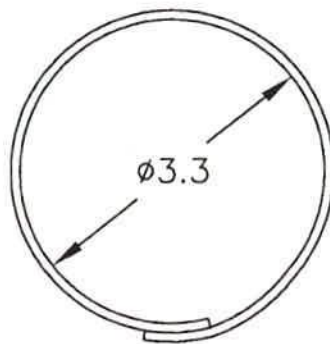
RELEASED

07 03 27

11.25

4.13

D3189-1 FLAT PATTERN

R0.063
(TYP)D3189-1 ROLLING DETAIL
NOT TO SCALED3189-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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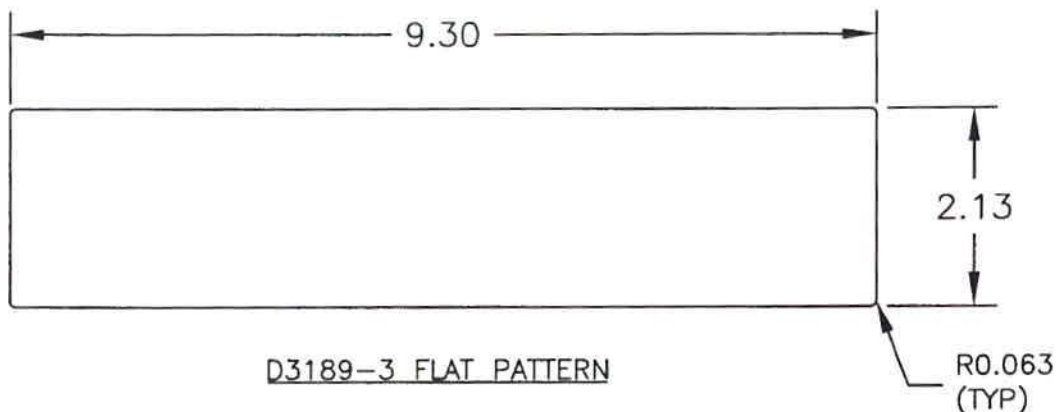
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DART

DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3189	REV. B SHEET 2 OF 2
DATE 07.01.05		TITLE CHAFING SHIELD	SCALE 1:2

RELEASED

07.03.27 [Signature]



D3189-3 ROLLING DETAIL
NOT TO SCALE

D3189-3 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
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- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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